

Work Order ID 73451

Page 1

Thursday, September 01, 2011 7:32:05 AM

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 8/31/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/09/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

ES 11/09/13 ⑥

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 ulor 13(H)

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:1510:45320076X 6 m L 11/09/14M 115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Item Name: Door Assembly

Stop



Start Date: 8/31/2011 Start Qty: 4.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

counted
6 6 11/10/11

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

8/11/09/14 (6)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S ulorly

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 73451

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Thursday, September 01, 2011 7:32:05 AM

Item ID: D3296-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Door Assembly
Start Date: 8/31/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 9/16/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Identify as per dwg & Stock Location: <u>ST218</u>	0.00							
Packaging	Memo	0.00							
170  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

Handwritten notes:
⑥x
Sp 11-09-15
11/9/15
MF 11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73451

Parent Item: D3296-041

Parent Item Name: Door Assembly



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	12.0000	1	4		8/31/09/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				12					
				71647				6					
				72725				6					
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	14.0000	1	4		8/31/09/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				14					
				71648				6					
				72726				8					
D3296-1 Door Panel		Manufactured	No			100	Each	10.0000	1	4		8/31/09/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST186				10					
				71719				10					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 01, 2011 7:32:02 AM

Page 2

Work Order ID: 73451

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3296-3 Manufactured No

100 Each

14.0000

1

4



Door Panel

Location

Loc Qty

Loc Code

ST186

2

68482

2

ST196

12

71717

12

MS20470AD4-6

Purchased No

100 Each

2,013.000

1

4



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2013

117395

502

117887

1511

D2137

Manufactured No

140 Each

20.0000

1

4



Decal - No Step

Location

Loc Qty

Loc Code

ST006

20

72053

20

D2419

Manufactured No

140 Each

10.0000

1

4



Handle

Location

Loc Qty

Loc Code

GA

10

69732

10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 01, 2011 7:32:03 AM

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Work Order ID: 73451

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2462 Manufactured No

140 f

457.8672 0.3333 1.3332



Seal



GB 11/09/14

Location

Loc Qty

Loc Code

ST404

457.8672

48530

457.8672

1.9998

D2728-1 Manufactured No

140 Each

0.0000 0 0



Dart Logo label

MS20470AD4-4

Purchased No

140 Each

3,760.000 25 100



GB 11/09/14

Rivet, Universal Head

GB 11/09/14

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

3682

116188

136

116391

66

118614 -

3480

150

NAS1149DN632J Purchased No

140 Each

960.0000 1 4



Washer

GB 11/09/14

Location

Loc Qty

Loc Code

ST297

960

118428

960

6

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 13451
02/11/09/01

D3161-7 HINGE

.063

D3296-1 DOOR
PANEL (1)

D3161-9
HINGE

0.125

D2419 HANDLE (1)
MS20470AD4-6 RIVET (1)
AN960JD6 WASHER (1)

D3296-3 DOOR PANEL (1)

0.240
13.563 (13 EQUAL SPACES)

Ø0.141 (TYP, 3 PLACES SHOWN)
MS20470AD4-4 RIVET
(25 PLACES)

Ø0.128
(TYP 11
PLACES)

NO STEP

D2137 DECAL

D2728-1
DECAL

1.95

0.75
D2462-0040 SEAL (1)
D2462-0053 SEAL (1)
D2462-0245 SEAL (1)
(TRIM TO FIT)

RELEASED
04.07.12

DART



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	UP	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	SCALE	1:3	

D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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